

Work Order ID 65041

Wednesday, January 05, 2011 3:04:48 PM



Page 1

Item ID: D4010-1

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 1/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-01-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4010

D

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

4

B

11/01/24

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 ALEXTRA

Temp:

Time IN:

7:00 PM 11/01/22

Time OUT:

7:00 AM 11/01/24

4

B

11/01/24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Start Date: 1/5/2011 Start Qty: 4.00

Required Date: 1/14/2011 Req'd Qty: 4.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------------|
| 110  Thermoform Thermoforming Machine | THERMOFORMING MACHINE Memo Thermoform as per Dwg. D4010-1 and Folio FTA067 using tool DT 9540 Dwg. Rev. <u>B</u> Folio Rev. <u>B</u> | 0.00 0.00 | | | | <u>4</u> | | | <u>B</u> 11/01/24 |
| 120  QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect for proper formation of each part | 0.00 0.00 | | | | <u>4</u> | | | <u>B</u> 11/01/24 |
| 130  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | <u>x24</u> | | | <u>OK</u> 11/01/24 |

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Cust Item ID:

Customer:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

0.00

1-Trim & Drill to Finished Dimensions as per dwg D4010-1

2- Use wearplate jig DT9542 to transfer drill holes in bearpaw as per dwg and use 0.375" unibite to open holes to finish size.

3- Chamfer all holes on both sides using appropriate 0-flute countersink bit.

x 4

Dhe
11/01/26

145

0.00



HandThermo

Hand Finishing Thermoforming

Anneal Material

Memo

0.00

Anneal trimmed & drilled product
at 250 deg. F. for 75 minutes & allow to cool in oven.

Time In: 250 8:15 am

Oven Off: 9:30 am

x 4

Dhe
11/01/27

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|-----------|--------------|---------------|---------------|------------------|-----------------|
| 150 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| QC Quality Control | Memo Check dimensions to ensure conformity to drawing tolerances. | 0.00 | | | | 27 | | | Sh. 11/01/07 |
| 160 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | 8402101 | | (x4) | | | |
| 170 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| Packaging Packaging | Memo | 0.00 | | WO# 65040 | | | | | Sh. 11/02/07 |

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/03 [Signature]
MF
11-02-03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 05, 2011 3:04:52 PM

Page 1

Work Order ID: 65041

Parent Item: D4010-1

Parent Item Name: Bearpaw



Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by:EC
 IPP Rev B. Improved process Add Step 105 (Drying) & 145
 (Annealling) to routings 10/03/31 DL
 10.05.27 per ECN10-575 DL

IPP Rev:C

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M-ALXTRAB-S.300 | | Purchased | No | | | 100 | sf | 336.6290 | 7.104 | 29.91158 | | | |



Alextra ET 0.300 sheet

Location

therm

Loc Qty

336.629

336.629

Loc Code

113108

29.91158 sq ft.

Dh
11/01/07

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NOTE: Date & initial all entries

| | | |
|---------------------------|---------------|------------------------------|
| DART AEROSPACE LTD | | Work Order: 65041 |
| Description: | | Part Number: 0-4010-1 |
| Inspection Dwg: D | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than " | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |

| | |
|------------------------|-----------------------|
| Measured by: Dh | Date: 11/01/2- |
|------------------------|-----------------------|

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 12.00" | ± 0.25" | 11.875" | ✓ | | | |
| 5.50" | ± 0.030" | 5.50" | ✓ | | | |
| 9.50" | ± 0.030" | 9.50" | ✓ | | | |
| 11.81" | ± 0.030" | 11.81" | ✓ | | | |
| 16.69" | ± 0.030" | 16.7" | ✓ | | | |
| 20.94" | ± 0.030" | 20.9" | ✓ | | | |
| 23.25" | ± 0.030" | 23.25" | ✓ | | | |
| 24.66" | ± 0.25" | 24.5" | ✓ | | | |
| 2.34" | ± 0.25" | 2.25" | ✓ | | | |
| 1.00" | ± 0.100" | 1.05" | ✓ | | | |
| 1.25" | ± 0.13" | 1.37" | ✓ | | | |
| 0.375" | ± 0.006" | 0.371" | ✓ | | | |

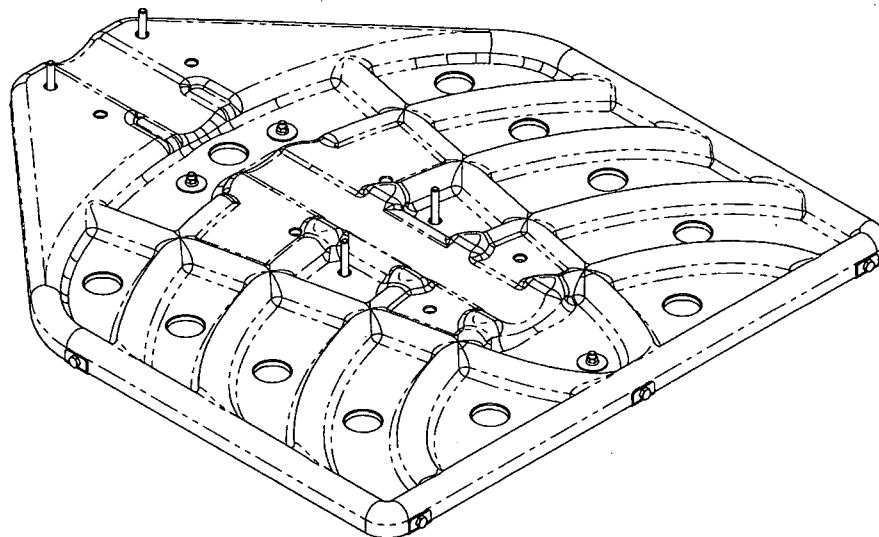
| | |
|------------------------|-----------------------|
| Measured by: Dh | Date: 11/01/27 |
|------------------------|-----------------------|

| | |
|----------------------|-----------------------|
| Audited by: B | Date: 11/01/27 |
|----------------------|-----------------------|

| | |
|------------------------------|--------------|
| Preliminary Approval: | Date: |
|------------------------------|--------------|

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| B | 10.04.14 | Added preliminary approval | KJ | |

10-04-14



D4010-041 BEARPAW ASSEMBLY (407)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65041

2811-01-5

RELEASED
2010-05-26
MB

| | | | |
|------------|---|--|----------|
| D | CHANGED NOTE 9 ON SHEET 3 (ZN A3-3); CHANGED Ø0.375 HOLE LOCATIONS FROM HARD CALL OUT TO REF (ZN'S D5-3, D6-3, D7-3); ADDED CHAMFERS TO ALL DRILLED HOLES (ZN B4-3, 2 PL); REMOVED BOSSES ON BOTTOM SURFACE AROUND Ø1.250 HOLES (ZN D4-3 ON PREVIOUS REVS); PICTORIAL CHANGE ON D4010-1 TO REFLECT MOLD REWORK (RECESSES FOR CLEARANCE OF BOTTOM SADDLE EDGE AND RIVET HEADS ON OEM SKIDTUBES). REASON: SEE PAR#10-020. | MB | 10.05.14 |
| C | OPTIMIZED DESIGN BASED ON FUNCTIONALITY AND TO EASE MANUFACTURING | MB | 09.11.10 |
| B | REDESIGNED; ADDED PROVISIONS FOR COMPATIBILITY WITH OEM SKIDTUBES/SADDLES; REDEFINED SOME TOLERANCE | MB | 09.11.02 |
| A | NEW ISSUE | MB | 09.10.22 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>MB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4010 TITLE BEARPAW (407) DATE 10.05.14 | |
| DRAWN | <i>MB</i> | | |
| CHECKED | <i>MB</i> | | |
| MFG. APPR. | <i>MB</i> | | |
| APPROVED | <i>MB</i> | | |
| DE APPR. | <i>MB</i> | REV. D SHEET 1 OF 3 SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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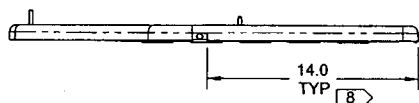
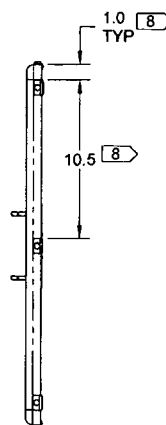
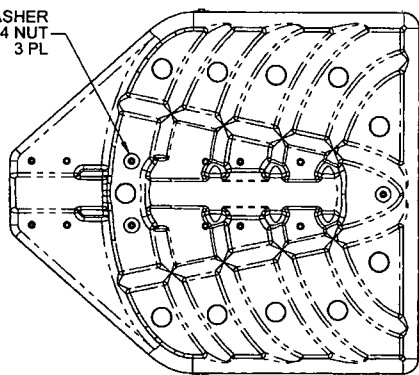
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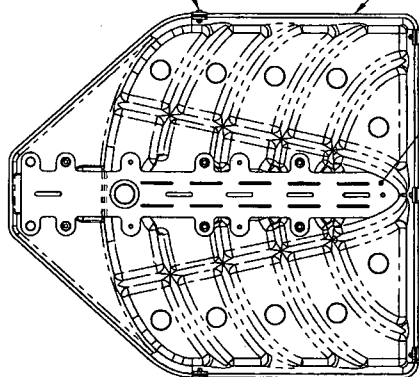
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NOTE: Date & initial all entries

D3456-1 WASHER
MS21043-4 NUT
3 PL



AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT



D4010-1
BEARPAW

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4013-041 WEARPLATE
ASSEMBLY

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4010-041 BEARPAW ASSEMBLY (407)

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|------------------------|
| 1 | X | D4010-041 | BEARPAW ASSEMBLY (407) |
| 2 | 3 | D3456-1 | WASHER |
| 3 | 1 | D4010-1 | BEARPAW |
| 4 | 1 | D4013-041 | WEARPLATE ASSEMBLY |
| 5 | 5 | D4015-041 | WEARBAR |
| 6 | 5 | AN3C5A | BOLT |
| 7 | 5 | MS21043-3 | NUT |
| 8 | 3 | MS21043-4 | NUT |

WLO 656411

RELEASED
2010-05-28

D4010-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 9.37 lbs
- 8) LOCATE D4015-041 (ITEM 5) AS SHOWN AND TRANSFER DRILL Ø0.191 HOLE FROM D4015-041 TO D4010-1 BEARPAW AND FASTEN USING PRESCRIBED HARDWARE.
- 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D4010 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BEARPAW (407) | NTS |
| DATE | 10.05.14 | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

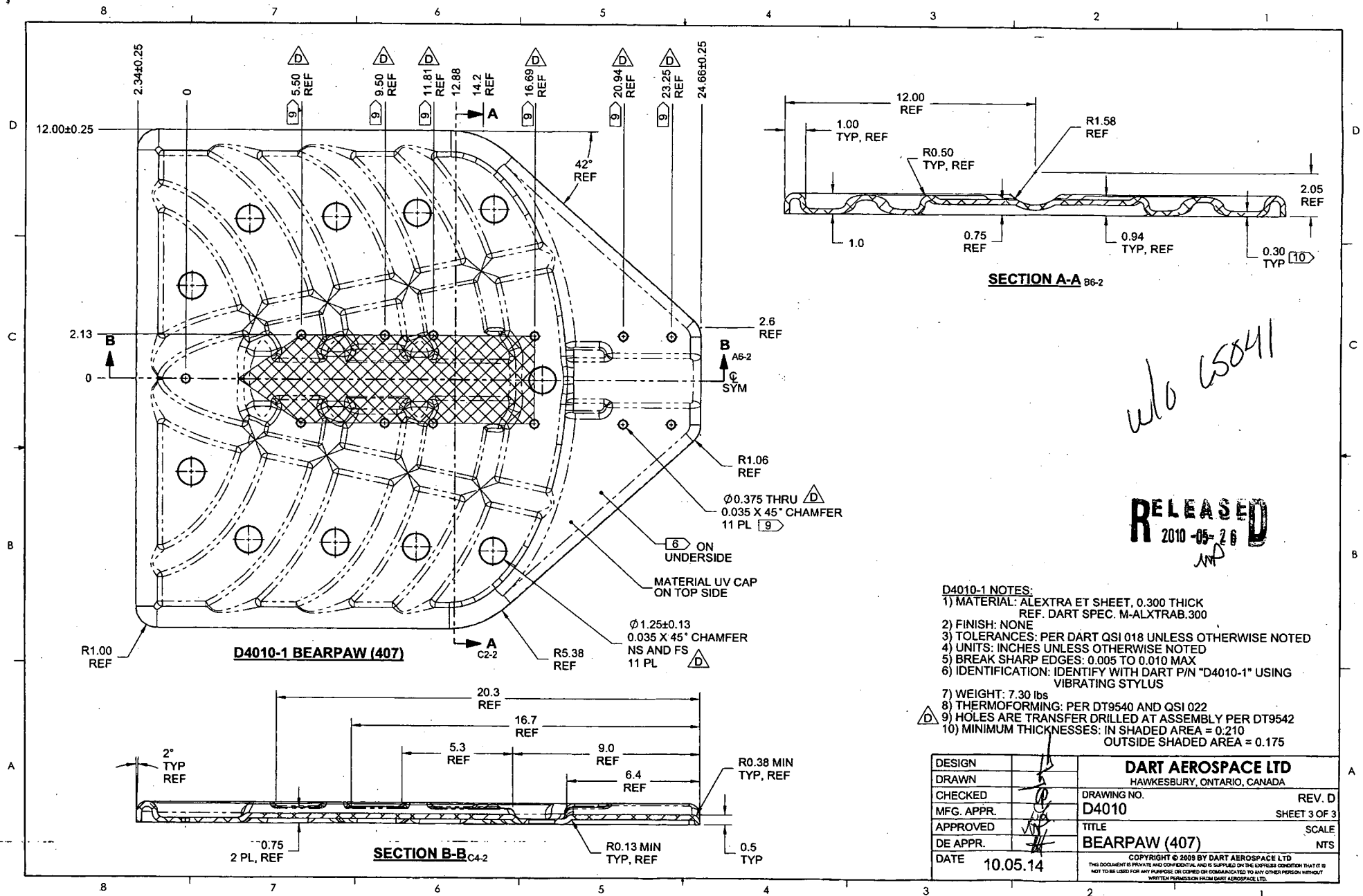
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